

Date: Wednesday, 5/31/2006 7:39:52 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 27306		
Estimate Number	: 11041		
P.O. Number	: N/A	Part Number	: D2809
This Issue	: 5/31/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2809 REV A1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 25959	Drawing Revision	: A1
	Type : MACHINED PARTS	Material	: N/A
Written By	: <i>See comment below</i>	Due Date	: 6/20/2006
Checked & Approved By	: <i>06.05.31</i>	Qty:	50 Um: Each
Comment	: Est C 02.03.07 Now turned in house NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.1045 f(s)/Unit Total : 5.2238 f(s)

6061-T6 Round Bar .500"

Material: 6061-T6 (QQ-A-250-11) rod .500"Ø

Batch: *M19296**J.G 06/06/04*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA204

J.G 06/06/04 50

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G 06/06/04 50

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 06/06/04 50

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & deburr all sharp edges as per dwg

SAD 06/06/05 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 04/06/14

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Drawing Name: BUSHING

Job Number: 27306

Part Number: D2809

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 06/06/13

(50)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder coat _____ per QSI 005 4.3

DL 06/06/13

(50)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57388

DL 06/06/14 50

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/06/14 (50)

Job Completion



DL 06/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

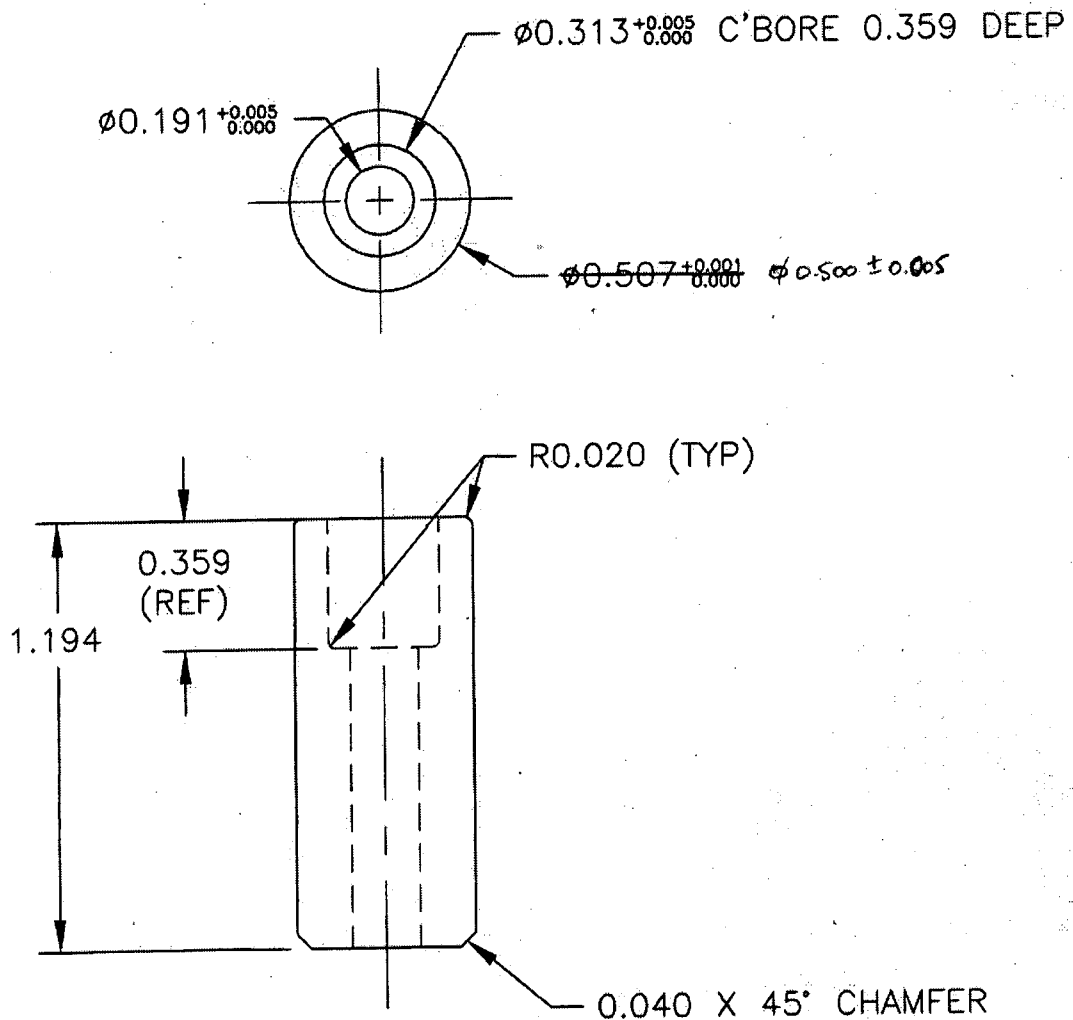
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	<i>CP</i> 01.04.26	ADD POWDER COAT; $\phi 0.500$ WAS $\phi 0.507$	

RELEASED
00.11.13 *[Signature]*

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **27306**

Per DART QSI 005 4.3

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